

Work Order ID 96966

Wednesday, February 13, 2013 9:16:37 AM

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Item ID: D4468-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Handle Adapter Assembly
 Start Date: 2/13/2013 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/22/2013 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MUF Date: 13-2-13 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4468	C

100 0.00

100

Waterjet Memo 0.00

FLOW CNC Waterjet CUT AS PER DWG

6061 .250x 2.00" BAR DWG REV: S
 PROG REV: S

DEBURR

102 QC2- Inspect parts off machine FAI/FAIB 0.00

102

QC Memo 0.00

Quality Control

Feb 22

DAS 05 8-89 13-2-24

DAS 05 8-89 13-2-24

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 2/13/2013 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 2/22/2013 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

103

Mill Conv

Conventional Milling Machine

Memo

OPEN HOLES TO CORECT SIZE

TAP DRILL FOR 8-32 HELICOIL

CSINK HOLES

0.00

104

QC8- Inspect parts - second check

0,00

104

QC

Quality Control

Memo

0.00

105

Chemical Conversion Coat per QSI005 4.1

0.00

105

HandFinish

Hand Finishing

Memo

0.00

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Item ID: D4468-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Handle Adapter Assembly
 Start Date: 2/13/2013 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/22/2013 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
106 *106* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00		DAS 16 9-83 13/3/11		(x2)			
109 *109* Small Fab Small Fab	Memo 1- Assemble as per dwg INSTAL HELICOILS	0.00 0.00		13-03-11		2			
110 *110* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SMP B3 11		2			

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N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 2/13/2013 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 2/22/2013 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

Accept
Qty

Reject Qty

Reject Number

**Insp.
Stamp**

150

0.00

150

0.00

Packaging

Memo

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

0.00

QC

Memo

Quality Control

MF

13-3-11

Picklist Print

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Page 1

Work Order ID: 96966

Parent Item: D4468-041

Parent Item Name: Handle Adapter Assembly

Start Date: 2/13/2013

Required Date: 2/22/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 12.01.12 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.000		Purchased	No				f	215.9270		0.5263158		13.02.24	
6061-T6 Bar .250 X 2.00													

Location	Loc Qty	Loc Code
MAT049	215.927	
107436	29.227	
122081	14.7	
123137	100	
123279	72	

MS21209C0815
Heli Coil, screw locking, red

Purchased No

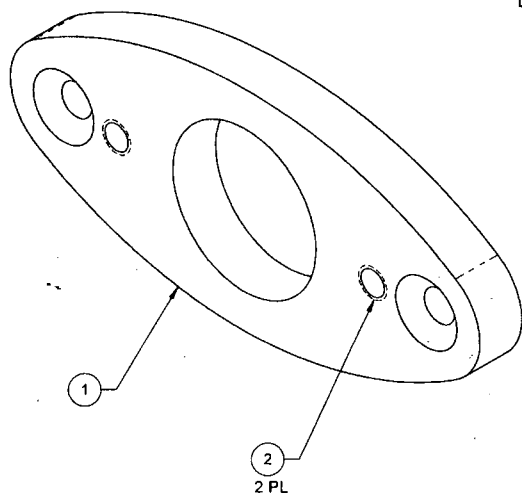
Each 203.0000

4

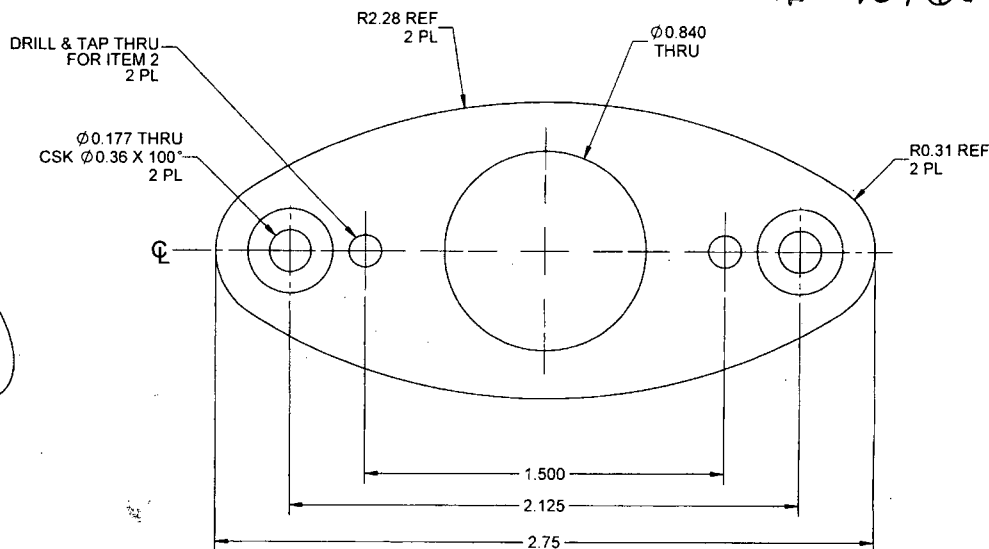
Location	Loc Qty	Loc Code
ST319	203	
119316	3	
124328	100	
124525	100	

4 13-03-11

ITEM	QTY	P/N	DESCRIPTION
	X	D4468-041	HANDLE ADAPTER ASSY
1	1	D4468-3	HANDLE ADAPTER
2	2	MS21209-C0815	THREADED INSERT, #8-32, LOCKING



D4468-041 HANDLE ADAPTER



D4468-3 HANDLE ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS4117/4115 OR QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.15 lbs

RELEASED
2012-11-29

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. C
MFG. APPR.	RP	D4468	SHEET 3 OF 3
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	HANDLE ADAPTER	NTS
DATE	12.10.04	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update </div> <div style="text-align: center;"> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div style="text-align: center;"> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div style="text-align: center;"> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div style="text-align: center;"> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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